

Work Order ID 84799

May-23-12 11:30:36 AM

84799

Page 1

Item ID: D2066

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Arm

Stop

NS2

Start Date: 23/05/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2066

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube
(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill using DT9034

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

5 ϕ FF 12-06-01

(XJ)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2066

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Arm

Stop *NS2*

Start Date: 23/05/2012 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 06/06/2012 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

Identify as per dwg & Stock Location: 257 0.00

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

5x 12-6-5 Sp

12/6/69

mf
12-06-05

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Picklist Print

May-23-12 11:30:40 AM

Page 1

Work Order ID: 84799

84799

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP D 02.03.18 Added pick list NG

IPP E 07.10.03 removed p/c EC verified by: DD

IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	20			
AN960.ID10					121524				**	20 (5)		FF	12-06-01
Washer													
D2052		Manufactured	No			100	Each	24.0000	2	10			
D2052									**	10 (5)		FF	12-06-01
Mounting Bracket													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					x GA 77088	24				2			
					73052	3							
					83341	21				8			
D2054		Manufactured	No			100	Each	24.0000	2	10			
D2054									**	(5)		FF	12-06-01
Bushing													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					GA	24				10			
					79836	24							
D2055		Manufactured	No			100	Each	16.0000	1	5			
D2055									**	(5)		FF	12-06-01
Clamp													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					GA	16				5			
					77110	16							

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Picklist Print

May-23-12 11:30:40 AM

Page 2

Work Order ID: 84799

84799

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

D2056 Manufactured No

100 Each 8.0000 1 5

D2056

Bell Crank

**

(5) FF 12-06-01

Location

Loc Qty

Loc Code

GA

8

71102

2

71889

6

5

MS21042L3

Purchased No

100 Each 2,418.000 2 10

MS21042L3

Nut

**

(5) FF 12-06-01

Location

Loc Qty

Loc Code

ST300

2418

117885

32

119017

1053

119075

138

121349

307

121444

888

10

MS27039-1-18

Purchased No

100 Each 51.0000 2 10

MS27039-1-18

Screw

**

(5) FF 12-06-01

Location

Loc Qty

Loc Code

ST291

51

115589

1

120308

25

121556

25

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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84799

Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 5.00

Required Qty: 5.00

M304TR0.500W.049

Purchased

No

120

f

223.9485

2.386

12.55789

M304TR0 500W 049

**

(5) FF 12-06-01

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT017

223.948478

111814

2.23

115010

109.254058

117598

3.97

119087

7.359

120633

101.13542

12.5
9.6
12.1

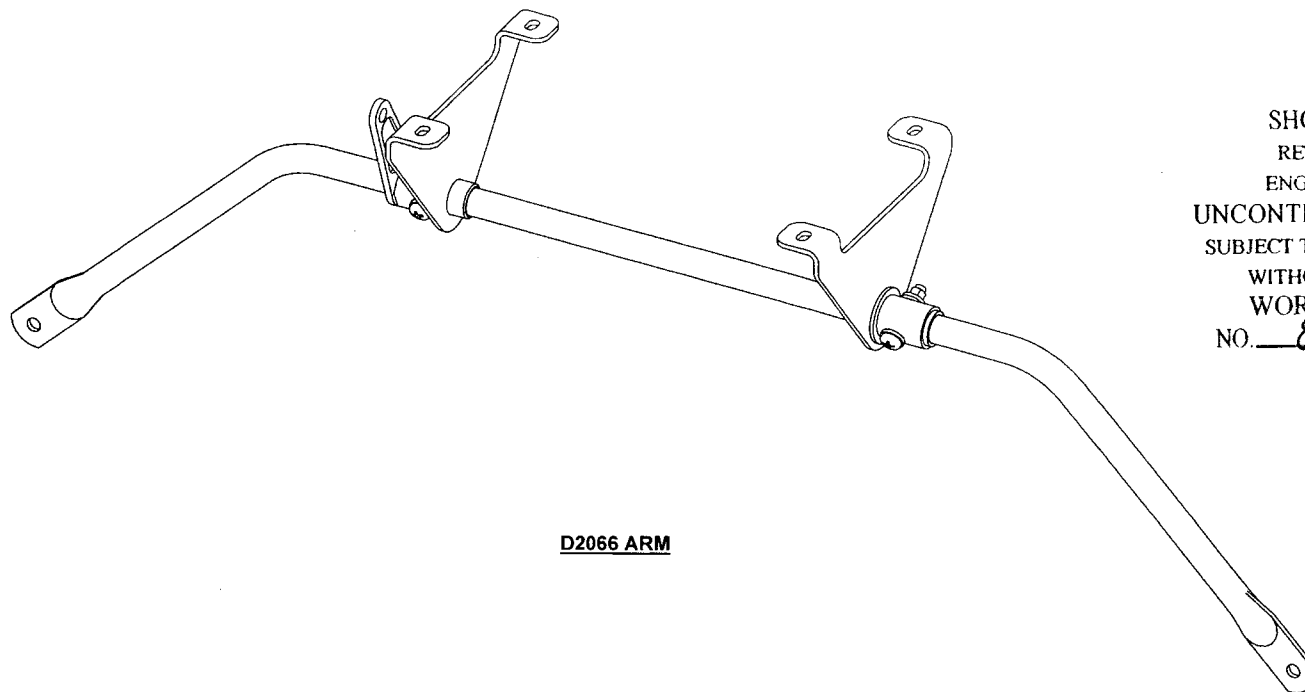
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D2066 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 89799 MLJ
12/05/23

RELEASED
08.06.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066: Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2066	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.12	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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8

7

6

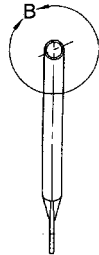
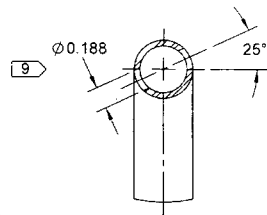
5

4

3

2

1



SECTION A-A

(SOME PARTS REMOVED FOR CLARITY)

DETAIL B
SCALE 3X
2 PL

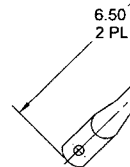
8 D2056
BELL CRANK

8 D2054
BUSHING
2 PL

8 D2052
BRACKET
2 PL

8 D2055
CLAMP

QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW



2.04
2 PL

9.10

45°
2 PL

D2066-1
ARM

MS27039-1-18 SCREW (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
2 PL

D2066-1 ARM BENDING DETAIL

(MAKE FROM D2066-1F)

8 D2056
BELL CRANK

D2054
BUSHING
2 PL 8

D2052
BRACKET
2 PL 8

D2055
CLAMP
8

D2066-1F
ARM

PUNCH PER D2727
2 PL 8

0.40
2 PL, REF

0.049
REF

0.500
REF

0.257
2 PL, REF

28.63

D2066-1F ARM CUT LENGTH DETAIL

NOTES:

1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500V.049)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)

8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM
AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED

9) DRILL $\phi 0.188$ AFTER BENDING

RELEASED
08-07-13

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D2066	SHEET 2 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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